

Date: Wednesday, 12/11/2008 1:40:55 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BACK FRAME ASSEMBLY
Job Number : 43380	
Estimate Number : 11129	
P.O. Number :	Part Number : D3017041
This Issue : 12/11/2008 S.O. No. :	Drawing Number : D3017 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 42442	Material :
Written By :	Due Date : 05/12/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JUD 08.11.12</u>	
Comment : Est. A 01.09.19 New issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4130NT0750W049	4130 RD Tube .750 x.049W
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Comment: Qty.: 13.1250 f(s)/Unit Total : 13.1250 f(s)
 4130 Tube .750 OD x.049W
 Cut- AISI 4130N tube, Ø3/4" x 0.049" wall
 Batch: M103012

11/08/11/21

2.0	D30177	Lug
-----	--------	-----



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
 Lug
 Pick:

Qty	Part Number	Description	Batch
3	D3017-7	Lug	<u>B38567</u>

11/08/11/21

3.0	D301711	cap
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 cap
 batch: B42354

11/08/11/21

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

- 1-Cut all tubes as per Dwg D3017
- 2-Bend tube as per dwg D3017
- 3-Drill holes in D3017-5 Using DT8622
- 4-Deburr

11/08/11/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/11/2008 1:40:55 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BACK FRAME ASSEMBLY

Job Number: 43380

Part Number: D3017041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Assemble and weld as per Dwg D3017 using Welding Jig DT8598

A/R 4130 Rod Batch: M19317

08/11/21

6-Drill holes in back frame using back panel drill jig DT8621

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

BE 08/11/24 (A)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/1/24 (A)

7.0

POWDER COATING

POWDER COATING



M 109648



(1X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*10:20
320°F
10:30*

M-A 08/11/24

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-24 (A)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

POD 43345

18 08/11/24 (X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/26 (A)

Job Completion



mf 08-11-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

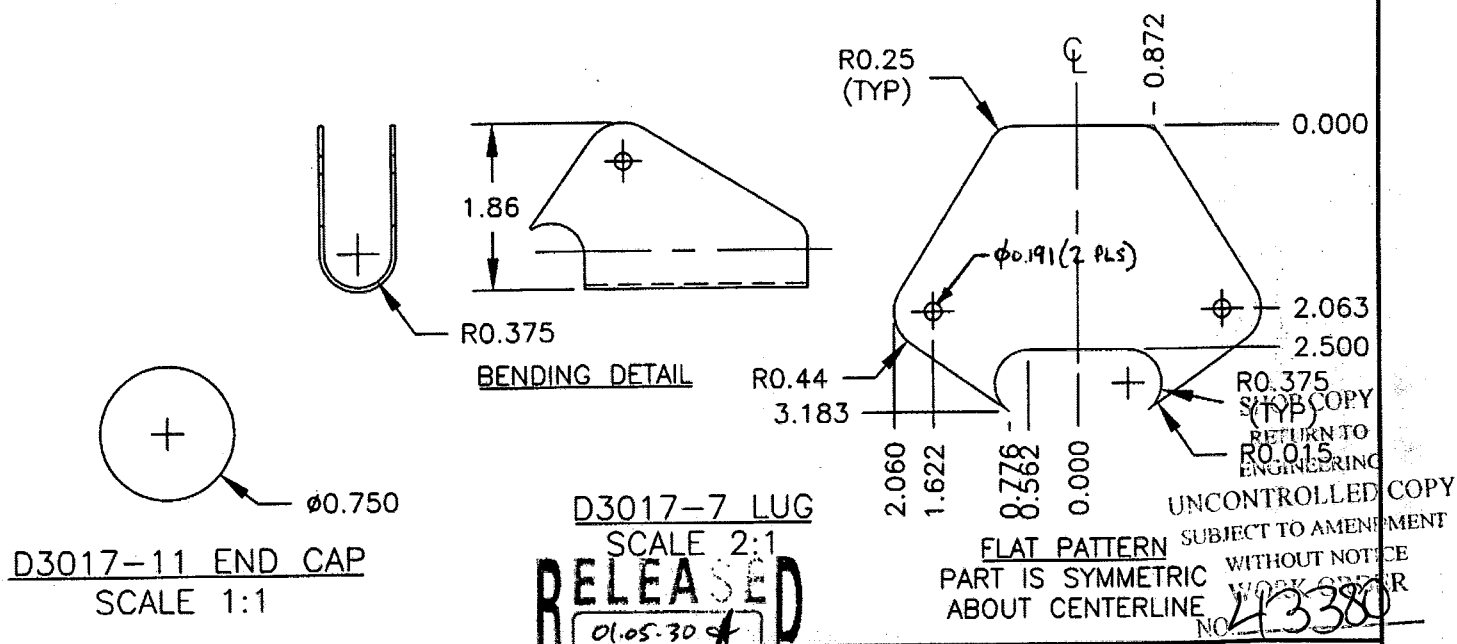


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3017	REV. A SHEET 1 OF 2
DATE 01.05.18		TITLE BACK FRAME ASSEMBLY	SCALE 1:1
A	01.05.18	NEW ISSUE	

QTY	PART No.	DESCRIPTION	MATERIAL
X	D3017-041	BACK FRAME ASSEMBLY	N/A
1	D3017-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3017-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3017-5	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
3	D3017-7	LUG	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3017-11	END CAP	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)

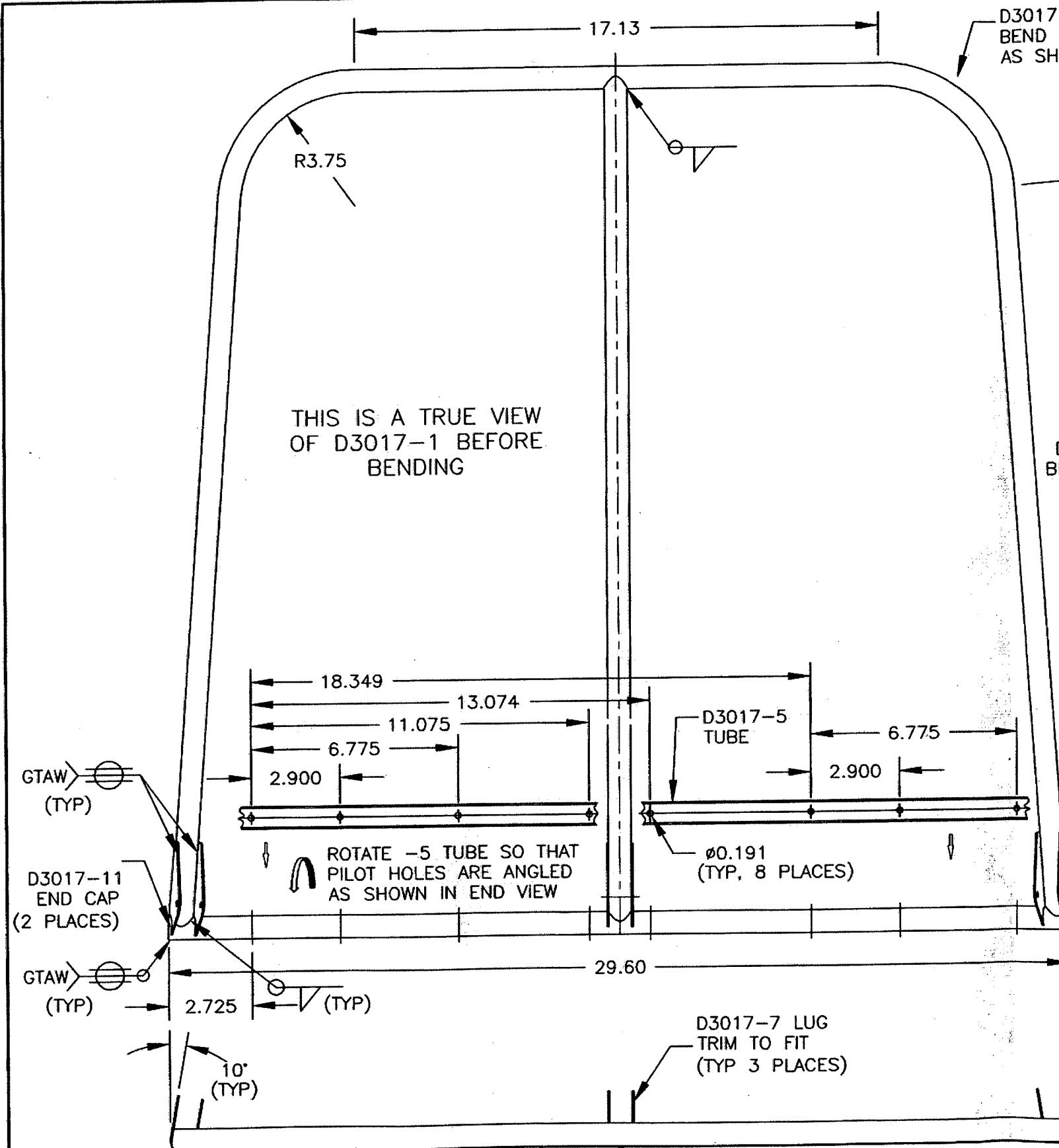
NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

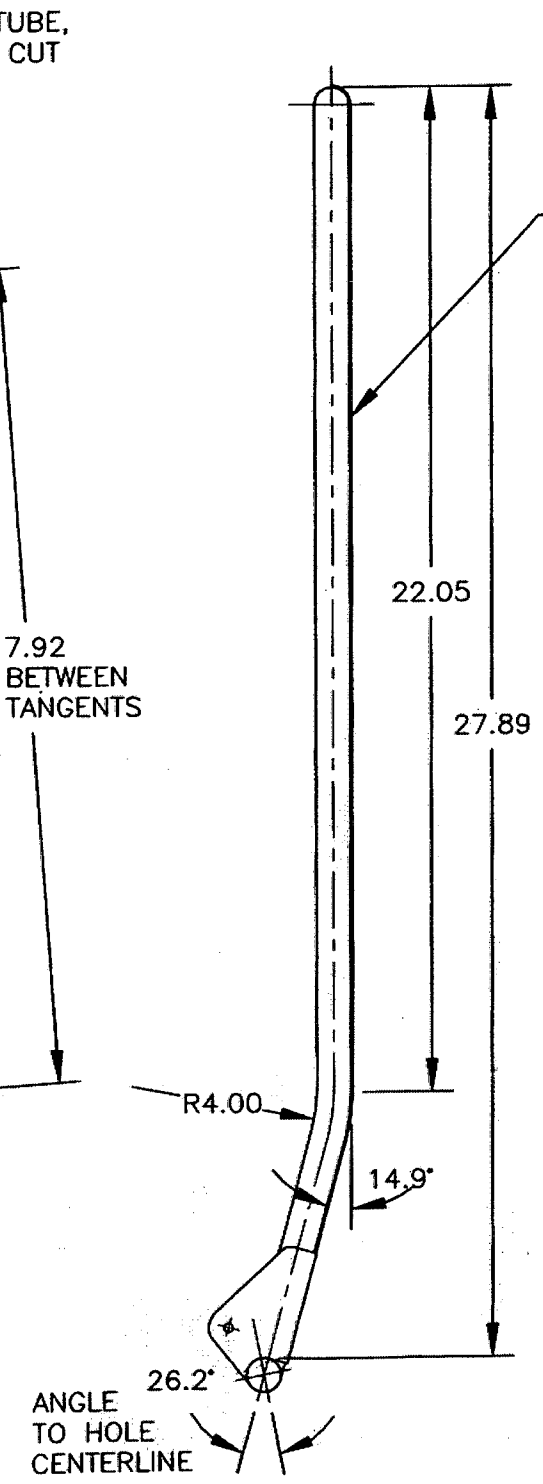


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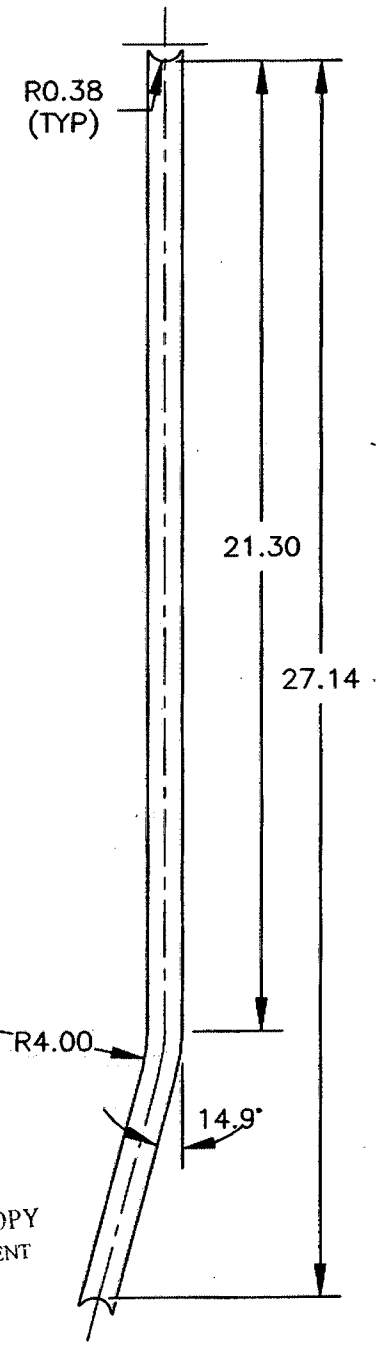
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17.92
DIST BETWEEN
BEND TANGENTS



DRILL Ø0.128 HOLES TO LINE UP
WITH D3023-1 BACK PANEL



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43380

D3017-3 TUBE

RELEASED
01-06-07

D3017-041 BACK FRAME ASSEMBLY
(D3017-1 TUBE, D3017-5 TUBE)

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		DATE	01.05.18	TITLE		BACK FRAME ASSEMBLY	SCALE 1:4

